Work Order ID 84768

84768

The May Coth Page 1

Wednesday, May 23, 2012 7:47:26 AM Item ID: D212-725-1-923 Accept *N900040100* **Revision ID:** Item Name: Bracket Ass'y **Start Date:** 5/23/2012 Start Qty: 1.00 **Cust Item ID:** Required Date: 5/28/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Date: 12-05-23 Tooling: Process Plan: M **Approvals:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Reject Tool ID Tool# Plan Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp **Draw Nbr Revision Nbr** D4260 Α 110 Pick Kit 0.00 *110* Packaging 0.00 Memo Packaging 120 0.00 *120* Small Fab 0.00 Memo Small Fab ASSEMBLE AS PER DWG 130 QC5- Inspect part completeness to step on W/O 0.00 QC 0.00 Memo Quality Control

W/O:		WORK ORDER CHANGES	· · · · · · · · · · · · · · · · · · ·				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
2012		D212-725-1-125 × 1 B84769 was found without. The bend (flat pattern only). Rework This part to continue on with assy.	San	12/05/28	1		NM 12-05-29
		Injection Level 5	-			٠	nh 12:05-29

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:		\ 	WORK ORD	ER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
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QC

Quality Control

Page 2

Wednesday, May 23, 2012 7:47:26 AM Item ID: D212-725-1-923 Accept *N900040100* Setup Start Revision ID: Item Name: Bracket Ass'y **Start Date:** Start Oty: 1.00 *1* 5/23/2012 **Cust Item ID:** Required Date: 5/28/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Approvals: Process Plan: Date: Tooling: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool ID Reject Tool# Plan Accept Reject Insp. **Work Center ID** Description **Run Hours** Oty Number Stamp Code Oty 140 Identify as per dwg & Stock Location: 0.00 *140* Packaging 0.00 Memo ***FLAT PATTERN ONLY*** Packaging 150 QC21- Final Inspection - Work Order Release 0.00 *150*

0.00

Memo

MLJ 12/05/29

W/O:			WC	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								•	
Part No		PAR #:							
	Re	esolution:	Disposition	1:	QA: N/C CI	osed:		Date: _	
NCR:		_	WORK ORDI	R NON-CONFORMA	NCE (NCR	1)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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Picklist Print

Wednesday, May 23, 2012 7:47:25 AM

Work Order ID:

84768

Parent Item:

D212-725-1-923

Parent Item Name:

Bracket Ass'y

Start Date: 5/23/2012

Required Date: 5/28/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

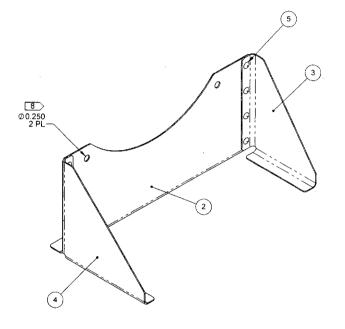
IPP REV:A 12.05.22 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-725-1-125		Manufactured	No			110	Each	0.0000	1	1		15	129
3racket D212-725-1-12 7		Manufactured	No			110	4 7 6 7 Each		1		1		
Gusset D212-725-1-129		Manufactured	No				4770 Each				12/1	1 10 S	125
Gusset		Manufactured				B84	1771			1	1	10 fos	//2
MS20615-4M4 Rivet		Purchased	No			110	Each	549.0000	8	8/)	
				Location		Loc Qtv	Loc	c Code					
				GA 119	396	549 549				7			

Page 1

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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	CEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		-							
Part No		PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:	
	Res	olution:	Dispositio	n:	_ QA: N/C (closed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NC	R)	-		
DATE	OTED	Description of NC		Corrective Action Section	ion B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
-									
								:	
· <u></u>									·
*** to \$1.00		·							

ITEM	QTY -923	PART NUMBER	DESCRIPTION
1	Х	D212-725-1-923	BRACKET ASSEMBLY
2	1	D212-725-1-125	BRACKET
3	1	D212-725-1-127	GUSSET
4	1	D212-725-1-129	GUSSET
5	8	MS20615-4M4	RIVET



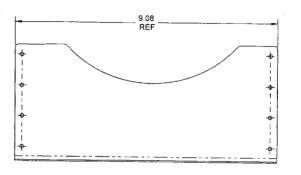
D212-725-1-923 BRACKET ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.58 lbs
8) TRANSFER Ø0.250 HOLES FROM FIRE EXTINGUISHER BOTTLE

Α	NEW ISS	UE		RF	11.02.24
REV.			DESCRIPTION	BY	DATE
DESIG	N	RF	DART AEROSPAC	`F I.	TD.
DRAW	N	RF	HAWKESBURY, ONTARIO,		
CHECK	KED	A	DRAWING NO.		REV. A
MFG. A	APPR.	W	□ D4260		SHEET 1 OF 7
APPRO	OVED	4	TITLE		SCALE
DE API	PR.	-W-	BRACKET ASSEMBLY		NTS
DATE	11.02	24	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPREST AND ENGINED ON THE EXPRESS CONDITION THAT IT IS		

W/O:			V	VORK ORDER CHANGE	S			·
DATE	STEP	PROC	EDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						,		
Part No	:	PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DQA:	Date: _	
	R	esolution:	_ Disposit	ion:	QA: N/C Cld	osed:	Date: _	
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NCR)		
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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- 0.040 REF 4.05 R0.13 0.70 REF



<u>D212-725-125 BRACKET</u> (MAKE FROM D212-725-1-125F FLAT PATTERN)



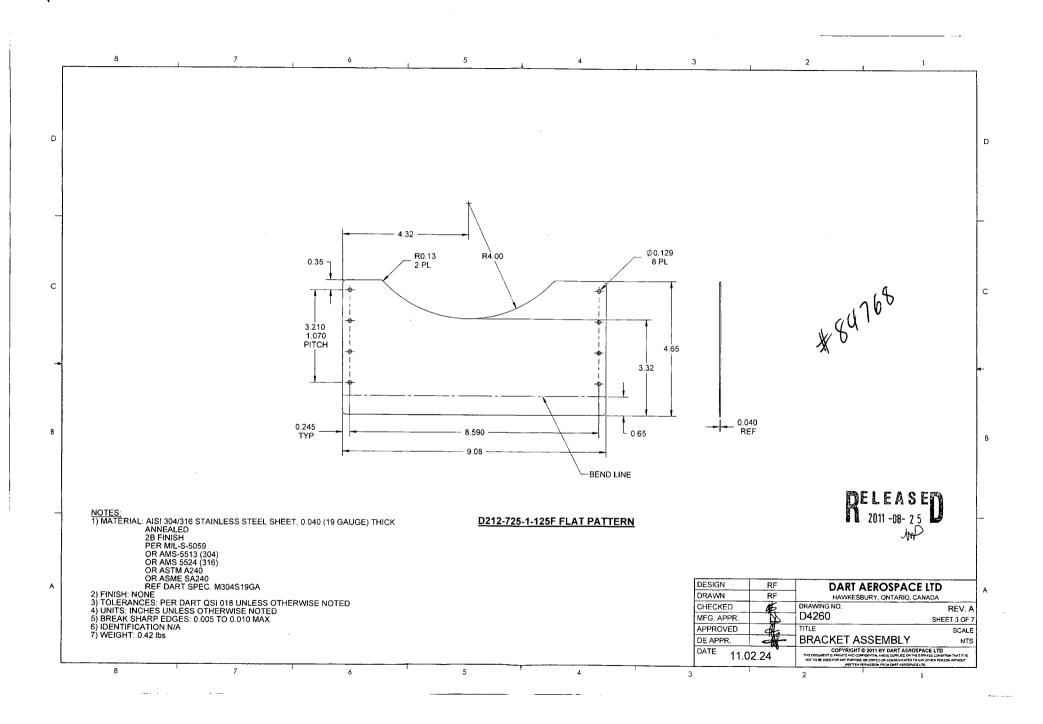
NOTES:
1) MATERIAL: MAKE FROM D212-725-1-125F FLAT PATTERN
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.42 lbs

DESIGN	RF	DART AEROSPACE	IID
DRAWN	RF	HAWKESBURY, ONTARIO, CA	
CHECKED	A.	DRAWING NO.	REV. A
MFG. APPR.	17	D4260	SHEET 2 OF 7
APPROVED	d a	TITLE	SCALE
DE APPR.	-//	BRACKET ASSEMBLY	NTS
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W/O:			W	ORK ORDER CHANG	ES			
DATE	STÉP	PRO	CEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								:
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQA :	Date: _	
	Re	esolution:	Dispositi	on:	_ QA: N/C Ck	osed:	Date: _	
NCR:		V	WORK ORE	DER NON-CONFORMA	NCE (NCR)		
DATE	STEP	Description of NC		Corrective Action Secti		Verification	Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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W/O:			V	ORK ORDER CHANG	ES			•
DATE STEP		PROCEDURE CHANGE				Date Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
								
		PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQA:	Date: _	
		solution:	Disposition:			osed:		
NCR:		\	WORK OR	DER NON-CONFORM	ANCE (NCR)		
DATE	STEP	Description of NC Section A			ion B	Verification		Approval
	JILF		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector
-								
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		*						
		-						

0.55 0 0 4.10 0 R0.13 -0.040 REF 0.55

<u>D212-725-1-127 GUSSET</u> (MAKE FROM D212-725-1-127F FLAT PATTERN)

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NOTES:
1) MATERIAL: MAKE FROM D212-725-1-127F FLAT PATTERN
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.13 lbs

DESIGN	RF	DART AEROSPACE	LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	A.	DRAWING NO.	REV. A	
MFG. APPR.	177	D4260	SHEET 4 OF 7	
APPROVED	Al-	TITLE	SCALE	
DE APPR.		BRACKET ASSEMBLY	NTS	
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8 D D 1.00 0.50 0.200 R0.13 TYP BEND LINE 0.350 Ø0.129 4 PL С 0 3.210 R0.078 3.91 1.070 PITCH 36° -BEND LINE 4.55 1.00 j 0.50 REF ₿ NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 (19 GAUGE) THICK ANNEALED
2B FINISH
PER MIL-S-5059
OR AMS-5513 (304)
OR AMS-5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC. M304S19GA **D212-725-1-127F FLAT PATTERN** DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.13 lbs DRAWN RF DRAWING NO. CHECKED REV. A D4260 MFG. APPR. SHEET 5 OF 7 APPROVED TITLE SCALE TITLE
BRACKET ASSEMBLY
NTS
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0.55 -0 0.55 0.040 REF

D212-725-1-129 GUSSET (MAKE FROM D212-725-1-129F FLAT PATTERN)



D

NOTES:
1) MATERIAL: MAKE FROM D212-725-1-129F FLAT PATTERN
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE	ITD	
DRAWN	RF	HAWKESBURY, ONTARIO, CA		
CHECKED	A.	DRAWING NO.	REV. A	
MFG. APPR.	77	D4260	SHEET 6 OF 7	
APPROVED	#	TITLE	SCALE	
DE APPR.	-	BRACKET ASSEMBLY	NTS	
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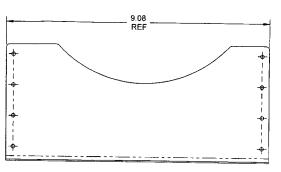
D 1.00 0.50 0.200 0.350 -3.210 BEND LINE 1.070 PITCH 4.55 45° Ø0.129 1.00 TYP REF 0.50 3.86 **D212-725-1-129F FLAT PATTERN** NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 (19 GAUGE) THICK ANNEALED
2B FINISH
PER MIL-S-5059
OR AMS-5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASTM 5A240
REF DART SPEC. M304S19GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs DESIGN DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D4260 MFG. APPR. SHEET 7 OF 7 TITLE

BRACKET ASSEMBLY

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- 0.040 REF 4.05 R0.13 0.70 REF



Meference only

<u>D212-725-125 BRACKET</u> (MAKE FROM D212-725-1-125F FLAT PATTERN)



8

- NOTES:
 1) MATERIAL: MAKE FROM D212-725-1-125F FLAT PATTERN
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.42 lbs

DESIGN RF		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN RF				
CHECKED	45	DRAWING NO.	REV. A	
MFG. APPR.	\mathcal{P}	D4260	SHEET 2 OF 7	
APPROVED	Altr.	TITLE	SCALE	
DE APPR.	-///	BRACKET ASSEMBLY	NTS	
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